

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019996**Date Inspected:** 01-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA

CWI Name:	Mr. Huang Min		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	OBG TRIAL ASSEMBLY		

Bridge No: 34-0006**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 6

Shielded Metal Arc (SMAW) welding of Weld Joint FB3169-003-040, And Welder is identified as 048659; ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2.

Shielded Metal Arc (SMAW) welding of Weld Joint FB3169-002-043, And Welder is identified as 053753; ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-P-2212-B-U2.

BAY 7

FCAW welding of welds joint W2-SB10-031-126~131, And Welder is identified as 053742, ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guo. The welding variables appeared to comply with the Applicable

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2132-3.

FCAW welding of welds joint W2-SB9-054-126~131, And Welder is identified as 217185, ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guo. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of welds joint W2-SB10-030-126~131, And Welder is identified as 215689, ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guo. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

BAY 8

FCAW welding of Weld joint BK004A5-055-126/127, And Welder is identified as 054459, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun the welding variables appeared to comply with the Applicable WPS-B-T-2132.

During the Quality Assurance In process observations of Fabrication of OBG Bike Path BK4A-055, 58, & 61, this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC has performed a CJP weld with backing. The backing was less than the full length of the joint...
- AWS D1.5 specifies steel backing shall be continuous for the full length of the each weld made with backing.

This QA informed ZPMC QC inspector identified as Liu Fa Wen and ABF QA inspector identified as Luo Lai Quan of this issue and that an incident report would be generated.

For further details see the attached photos and the incident report generated by this QA on this date.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Tharikoppada,Reddy

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer